

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011435**Date Inspected:** 30-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

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This QA inspector observed ZPMC qualified welding personnel identified as 051356 perform Flux Cored Arc Welding (FCAW) welding on Edge Plate, weld joint identified as EP137-001-009 & 010. ZPMC QC is identified as Mr.Tang Yajun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U2-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067764 perform Shielded Metal Arc welding (SMAW) Welding on Segment 11BW, weld joint identified as SEG067A-024. ZPMC QC is identified as Mr.Tang Yajun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-B-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 044772 perform SMAW Welding on Segment 11BW, weld joint identified as SEG067A-026. ZPMC QC is identified as Mr.Tang Yajun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-B-Tc-U4b-FCM-1.

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This QA inspector observed ZPMC qualified welding personnel identified as 044771 perform Submerge Arc Welding (SAW) Welding on Segment 12AE, weld joint identified as SEG3001AL-009. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 045265 perform SAW Welding on Segment 11DW weld joint identified as SEG071*-002 (DP133A+DP160A) & SEG073*-005 (DP215A+DP242A). ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 051348 & 058242 perform SMAW Welding on Segment 11EW, weld joint identified as SEG073A-004 (DP171A+BP109A). ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 067829 perform SMAW Welding on Segment 11EW weld joint identified as SEG073A-007 (SP786A+BP163A). ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM-1.

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This QA inspector observed ZPMC qualified welding personnel identified as 062731 & 062732 perform Flux Cored Arc Welding (FCAW) welding on Bottom Plate, weld joint identified as BP026-014-004~023. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
